

Work Order ID 47620

November 17, 2009 7:55:38 AM



Page 1

Item ID: D350-589-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Assembly LH

Start Date: 11/17/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/04/09 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *CL*

Date: *09/11/17* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2991	D
DSI 9463	A
IIN-D350-589	E

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP D350-589-041/DSI 9463
CHG005

N/A

8/6/24

for ~~CL~~ CL 10/03/22

(Ato) →

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

IT 10-03-17

W/O: 47620		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.03.17	103	Trim to fit mac up helicopter (Edge of door)	ST 10.03.17 permanent change	10.03.17	4		S 06/17
10.03.17	105	QC6	ST 10.03.17 permanent change	10/03/17	4		S 10/03/17

Part No: D350-589-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 47620

November 17, 2009 7:55:38 AM



Page 2

Item ID: D350-589-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Assembly LH

Start Date: 11/17/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/04/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

BT 10-03-17

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/17

Ⓟ

160



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

Plup/24 Ⓟ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 47620

November 17, 2009 7:55:38 AM



Page 3

Item ID: D350-589-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Assembly LH

Start Date: 11/17/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/04/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC4- 100% Inspect kits for completeness

0.00

S. 10/12/24



QC

Memo

0.00

Quality Control

④

Pro →

180

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-589-041/ DSI 9463

Location:

PPP rev: FC 112

P. 10/13/24 ①

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24 HJ

P. 10-3-24
①

W/O: 47620		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		Perm. Change Per DSZ 9447						
		Missing DSI 9447-041 B* 53111 Qty +1 Per Kit CHL7001	PC	14/3/24	5		S 10/03/24	
		Missing DSI 9446-041 B* 45995 Qty +1 Per Kit CHL7001	PC	14/3/24	5		S 10/03/24	
		ADD missing DSZ to w/o + Bom. ADD copy of new Bom Per Ref.	AA	10.03.24			S 10/03/24	

Part No: D350-589-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 7:55:37 AM

Page 1

Work Order ID: 47620

Parent Item: D350-589-041RevC

Parent Item Name: Side Door Assembly LH




Comments: IPP RevE: per DSI 9463 DD verified by:

Start Date: 11/17/09

Required Date: 12/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2991-1RevU/R 		Manufactured	No			110	Each	0.0000	1.0000			
Side Door D2621RevB 		Manufactured	No			110	Each	66.0000	4.0000			
Latch Plate, 350 Spacepod												
				<u>Warehouse</u>	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
				Main Warehouse								
				ST		66						
				46842		66						
D2586RevD 		Manufactured	No			110	Each	104.0000	4.0000			
Door Latch												
				<u>Warehouse</u>	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
				Main Warehouse								
				ST		104						
				23082		0						
				45554		1						
				47183		3						
				50213		100						

B56416

B55314

x2
x1

BT 10-03-17

BT 10-03-17

X3

BT 10-03-17

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 47620

Parent Item: D350-589-041RevC

Parent Item Name: Side Door Assembly LH


Comments: IPP RevE: per DSI 9463 DD verified by:

Start Date: 11/17/09

Required Date: 12/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15  Screw		Purchased	No			110	Each	178.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	178	
106903	3	
108169	4	
109321	4	
111916	67	
112794	100	

D2464-1700RevB Manufactured



Neoprene Seal

D3085-041RevA1

Manufactured



prop ass'y

No	110	Each	0.0000	1.0000
----	-----	------	--------	--------

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	6	
47186	2	
47687	4	

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Page 3

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Work Order ID: 47620



Parent Item: D350-589-041RevC



Parent Item Name: Side Door Assembly LH

Start Date: 11/17/09

Required Date: 12/04/09

Comments: IPP RevE: per DSI 9463 DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2585RevB Mounting Channel		Manufactured	No			110	Each	45.0000	4.0000 3.14			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

4

45888

4

Main Warehouse

ST37

41

50544

2

51526

39

MS21042L3



Purchased

No

110

Each

3,038.000 ~~4.0000~~ 3.14

Nut

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

3038

110844

32

111274

27

111668

487

112314

1992

112385

500

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 47620

Parent Item: D350-589-041RevC

Parent Item Name: Side Door Assembly LH

Comments: IPP RevE: per DSI 9463 DD verified by:

Start Date: 11/17/09

Required Date: 12/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD10

Purchased

No

110

Each

2,498.000

4.0000



Washer

NAS1149003635

open
QSR 17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2498

105442

19

109059

2

109840

23

110985

202

111279

5

111668

64

112314

965

112369

218

113149

1000

MS20470AD4-5

Purchased

No

160

Each

2,621.000

8.0000



Rivet, Universal Head

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2621

111916

2621

ST 10-03-17

B113288

614

11/13/09

11/19/09

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 47620

Parent Item: D350-589-041RevC

Parent Item Name: Side Door Assembly LH


Comments: IPP RevE: per DSI 9463 DD verified by:

Start Date: 11/17/09

Required Date: 12/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-4A  Bolt		Purchased	No			160	Each	2,137.000	6.0000			

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	2137	
103915	78	
104214	500	
104291	300	
104322	200	
104374	200	
104625	300	
104817	559	

7/10/214

D2237RevD1

Manufactured No


Striker Plate

160 Each 75.0000

4.0000



55006

Rec'd 11/24/09

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	5	
46162	5	
Main Warehouse		
ST022	70	
50348	15	
52327	55	

November 17, 2009 7:55:37 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 7:55:37 AM

Page 6

Work Order ID: 47620

Parent Item: D350-589-041RevC

Parent Item Name: Side Door Assembly LH



Comments: IPP RevE: per DSI 9463 DD verified by:

Start Date: 11/17/09



Required Date: 12/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2589RevA  Keys, Key Chain, 350 Hinge		Manufactured	No			160	Each	60.0000	1.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	60	
46840	20	
50378	40	

MS21042L3  Nut		Purchased	No			160	Each	3,038.000	6.0000 			
--	--	-----------	----	--	--	-----	------	-----------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3038	
110844	32	
111274	27	
111668	487	
112314	1992	
112385	500	

46840

m113537 (11/13/09) (1)

November 17, 2009 7:55:37 AM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2991-1/-2/-3 SIDE DOOR

NOTES

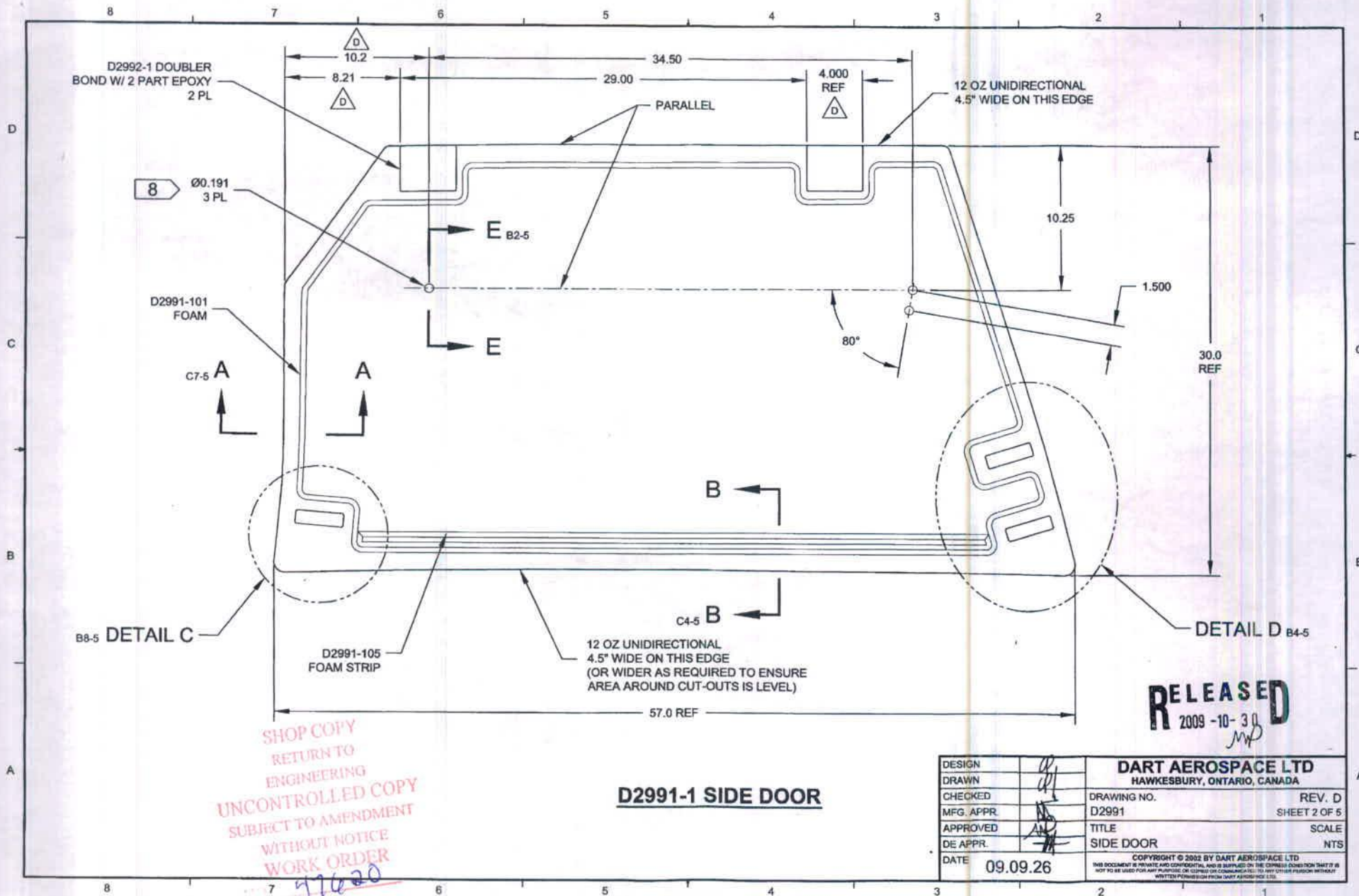
- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: NONE
- 13) WEIGHT: 9 lbs TYP

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47620
C20911117

RELEASED
2009-10-30

D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2991	REV. D SHEET 1 OF 5
TITLE SIDE DOOR	SCALE NTS
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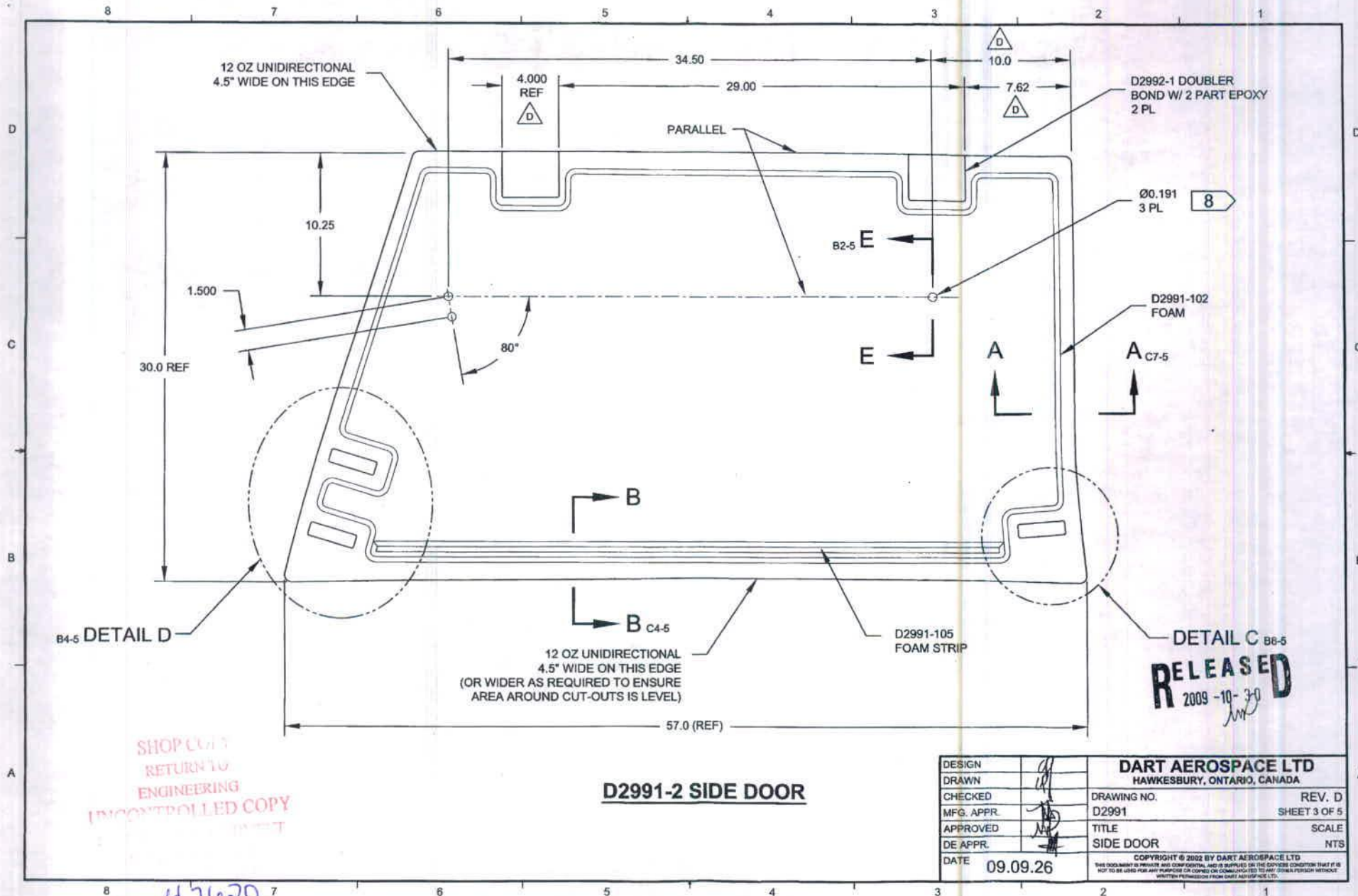


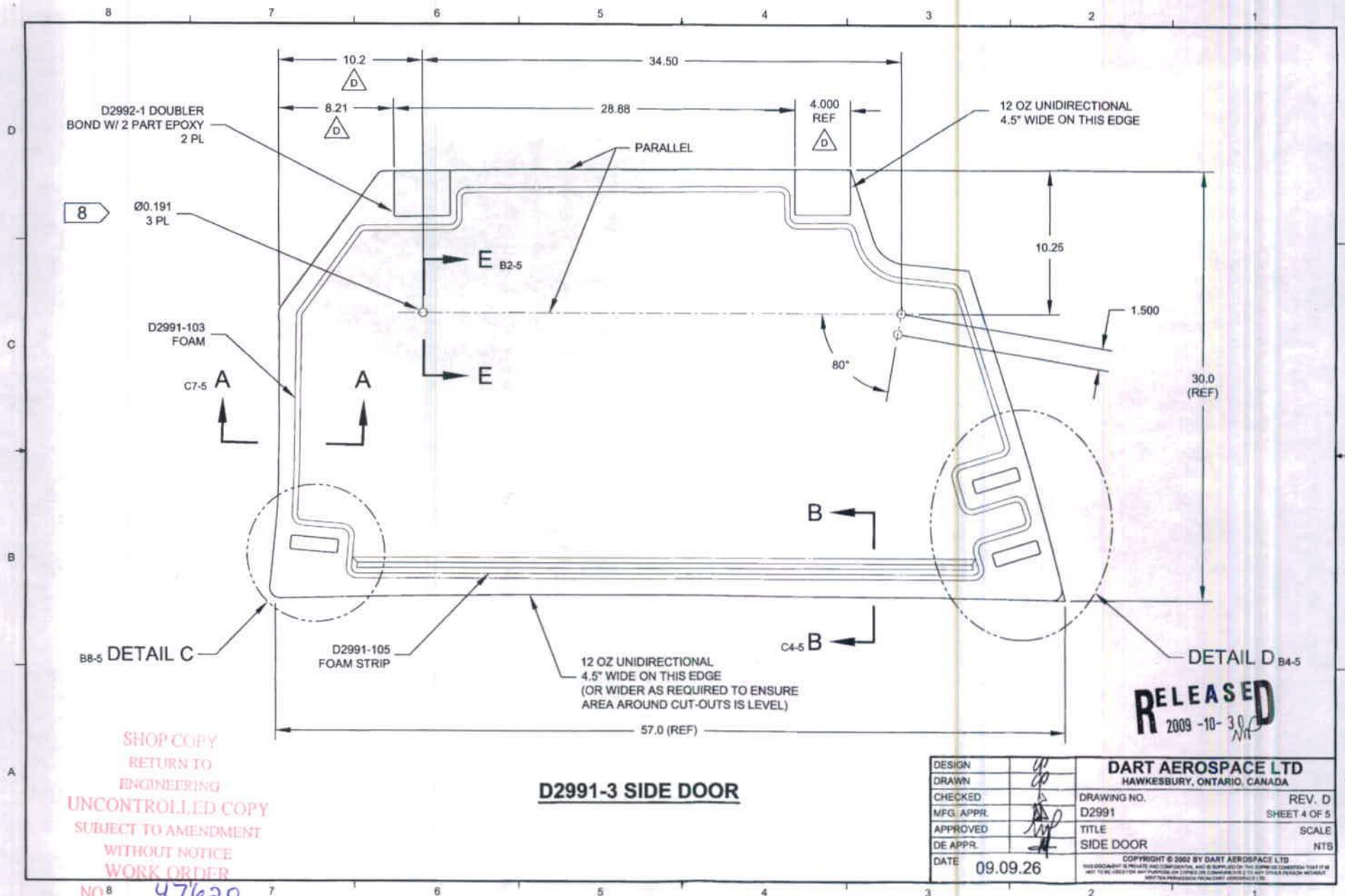
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WITHOUT NOTICE
WORK ORDER

D2991-1 SIDE DOOR

RELEASED
2009-10-30
MB

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2991	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	09.09.26	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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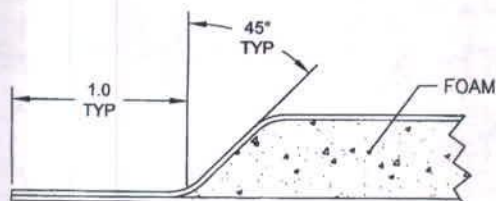
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NO 8 47620

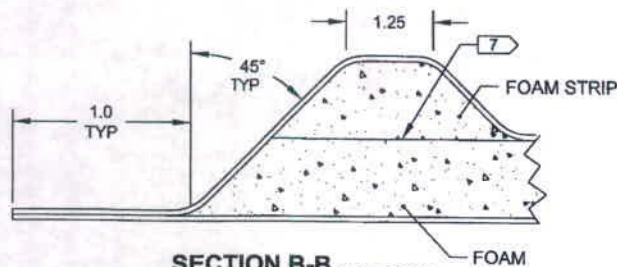
D2991-3 SIDE DOOR

RELEASED
2009-10-30

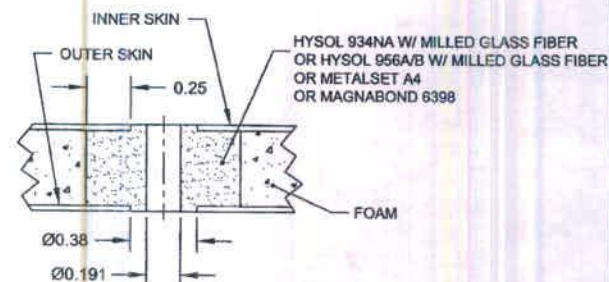
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2991	SHEET 4 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		SIDE DOOR	NTS
DE APPR.		COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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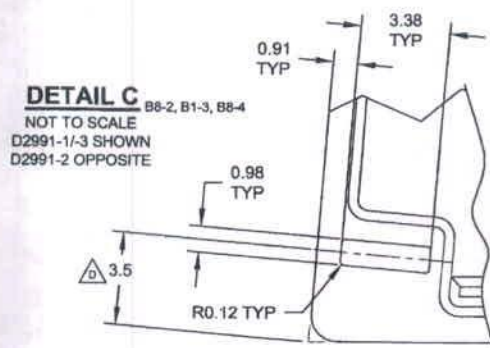
SECTION A-A C7-2, C2-3, C7-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



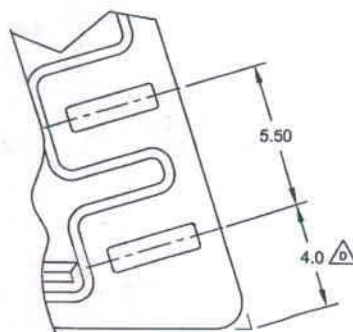
SECTION B-B B4-2, B5-3, B4-4
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION E-E D6-2, D3-3, C6-4
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE



DETAIL C B8-2, B1-3, B8-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D B1-2, B8-3, B1-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

RELEASED
2009-10-30

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47620

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2991	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NT
DATE	09.09.26	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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Work Order ID 47620

Friday, June 26, 2009 9:17:52 AM



Page 1

Item ID: D350-589-041
Revision ID: C
Item Name: Side Door Assembly LH

Accept



Setup Start



Stop



Start Date: 7/15/2009 Start Qty: 1.00
Required Date: 8/3/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2991	Rev C

100

DC
Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPP D350-589-041 CHG002

110

Purchasing
Purchasing

Purchasing

0.00

Memo

0.00

Issue P/O: _____ ☐ Description: D2991-1 side
door ☐ Supplier: Delastek batch: ☐ Ship to
delastek: Qty 2 D2992-1 Doubler ☐ Ensure batch # on
Label D3721-1 match W/O # for D350-58

120

Packaging
Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure certificate of conformity is attached

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

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1000

1000

1000

1000

1000

Work Order ID 47620

Friday, June 26, 2009 9:17:52 AM

Page 2

Item ID: D350-589-041
Revision ID: C
Item Name: Side Door Assembly LH

Accept



Setup Start



Stop



Start Date: 7/15/2009 Start Qty: 1.00
Required Date: 8/3/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Ensure Material certification comply to Dwg D2991

140



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

China 1974
1974 1974 1974 1974
1974 1974 1974 1974

China 1974
1974 1974 1974 1974
1974 1974 1974 1974

China 1974
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1974 1974 1974 1974
1974 1974 1974 1974

Work Order ID 47620

Friday, June 26, 2009 9:17:52 AM



Page 3

Item ID: D350-589-041
Revision ID: C
Item Name: Side Door Assembly LH

Accept



Setup Start



Stop



Start Date: 7/15/2009 Start Qty: 1.00
Required Date: 8/3/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

170



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

180



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

1937

1938

1939

1940

1941

1942

1943

1944

1945

1946

Work Order ID 47620

Friday, June 26, 2009 9:17:52 AM



Page 4

Item ID: D350-589-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Side Door Assembly LH



Start Date: 7/15/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00

Customer:



Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Picklist Print

Page 1

Friday, June 26, 2009 9:17:51 AM

Work Order ID: 47620

Parent Item: D350-589-041RevC

Parent Item Name: Side Door Assembly LH










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2992-1RevU/R 		Manufactured	No			120	Each	0.0000	2.0000			
Doubler MS21042L3 		Purchased	No			120	Each	0.0000	3.0000			
Nut AN960JD10 		Purchased	No			140	Each	0.0000	3.0000			
Washer D2464-1700RevB 		Manufactured	No			140	Each	0.0000	1.0000			
Neoprene Seal D2585RevB 		Manufactured	No			140	Each	0.0000	3.0000			
Mounting Channel D2586RevD 		Manufactured	No			140	Each	0.0000	3.0000			
Door Latch D2621RevB 		Manufactured	No			140	Each	0.0000	3.0000			
Latch Plate, 350 Spacepod D2991-1RevU/R 		Manufactured	No			140	Each	0.0000	1.0000			
Side Door D3085-041RevA1 		Manufactured	No			140	Each	0.0000	1.0000			

prop ass'y

THE UNIVERSITY OF CHICAGO

PHYSICS DEPARTMENT

RECEIVED

1964

1964

1964

1964

1964

1964

1964

1964

1964

1964

1964

1964

1964

1964

1964

1964

1964

1964

5

8

12

15

18

21

24

27

30

33

36

39

42

Picklist Print

Friday, June 26, 2009 9:17:51 AM

Page 2

Work Order ID: 47620

Parent Item: D350-589-041RevC

Parent Item Name: Side Door Assembly LH















Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 		Purchased	No			140	Each	0.0000	6.0000 			
Nut MS27039-1-15 		Purchased	No			140	Each	0.0000	3.0000 			
Screw AN3-4A 		Purchased	No			170	Each	0.0000	6.0000 			
Bolt D2237RevD1 		Manufactured	No			170	Each	0.0000	3.0000 			
Striker Plate D2589RevA 		Manufactured	No			170	Each	0.0000	1.0000 			
Keys, Key Chain, 350 Hinge D3721-1RevA 		Manufactured	No			170	Each	0.0000	1.0000 			
Decal MS20470AD4-5 		Purchased	No			170	Each	0.0000	6.0000 			
Rivet, Universal Head												

Friday, June 26, 2009 9:17:51 AM

Shop Packet Print

Page 2

Date: Wednesday, 29/04/2009 3:03:39 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SIDE DOOR
 Job Number : 47620
 Estimate Number : 12295
 P.O. Number :
 This Issue : 29/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : PURCHASED PARTS
 Previous Run : 47619
 Part Number : D350589041
 Drawing Number : D2991 REV.C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 20/05/2009 Qty: 1 Um: Each

Written By :
 Checked & Approved By : Julie Dawson
 Comment : est rev. A 06.02.16 new issue (was done on D350-589-041)

EC
 Est Rev:B 08-02-20 ECN 1096 DD verified by:EC
 est rev C 08.06.26 Revised pik list per QC comment (w/o
 25885) EC verified: DD
 est rev D 09.02.18 ecn 09-523 , CHG 003 EC verified
 by:DD



Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 ✓ DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-589-041 CHG 003 CHG 004 PTD 09.05.01

2.0 OUTSIDE SERVICE

OUTSIDE SERVICES-ENGINEERING



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 8723

Description: D2991-1 side door

Supplier: Delastek

Ship to delastek: Qty 2 D2992-1

Doubler

batch:

B47743

Ensure batch # on Label D3721-1 match W/O # for D350-589-041

Certificate of Conformity and process sheet from Delastek is required

3.0 D29921

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Doubler

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.05.09	1	KITS NOW AT CHG 004 W/ 4.00" WIDE DZ992-1 DOUBLER						
09.05.01	2	SHIP MODIFIED DZ992-1 DOUBLER 4.00" WIDE x 3.250" TALL x 0.040" THICK 5052-H32 W/ RD.250 CORNERS B/N						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date, & initial all entries

Date: Wednesday, 29/04/2009 3:03:39 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47620

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D29911

Side Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Side Door

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

**ENGINEERING
APPROVAL**

6.0

QC6

DIMENSIONAL CHECK



Comment: Ensure Material certification comply to Dwg D2991

7.0

D24641700

Neoprene Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2464-1700	Foam seal	

8.0

D2585

Mounting Channel



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2585	Latch clamp	

9.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2586	Door latch	

10.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2621	latch plate	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date, & initial all entries

Date: Wednesday, 29/04/2009 3:03:40 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47620

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3085041

prop ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3085-041	prop ass'y	

12.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
6	MS21042L3	Nut	

13.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	AN960JD10	Washer	

14.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	MS27039-1-15	Screw	

15.0

D37211

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: _____

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date, & initial all entries

Date: Wednesday, 29/04/2009 3:03:40 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47620

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick list:

19.0

D38941

Switch Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Plate

Batch: _____

20.0

D38951

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch: _____

21.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2237	Striker Plate	_____

22.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2589	keys, key chain	_____

23.0

AN34A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
6	AN3-4A	Bolt	_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date, & initial all entries

Date: Wednesday, 29/04/2009 3:03:40 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47620

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
6	MS20470AD4-5	Rivet	

25.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

26.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

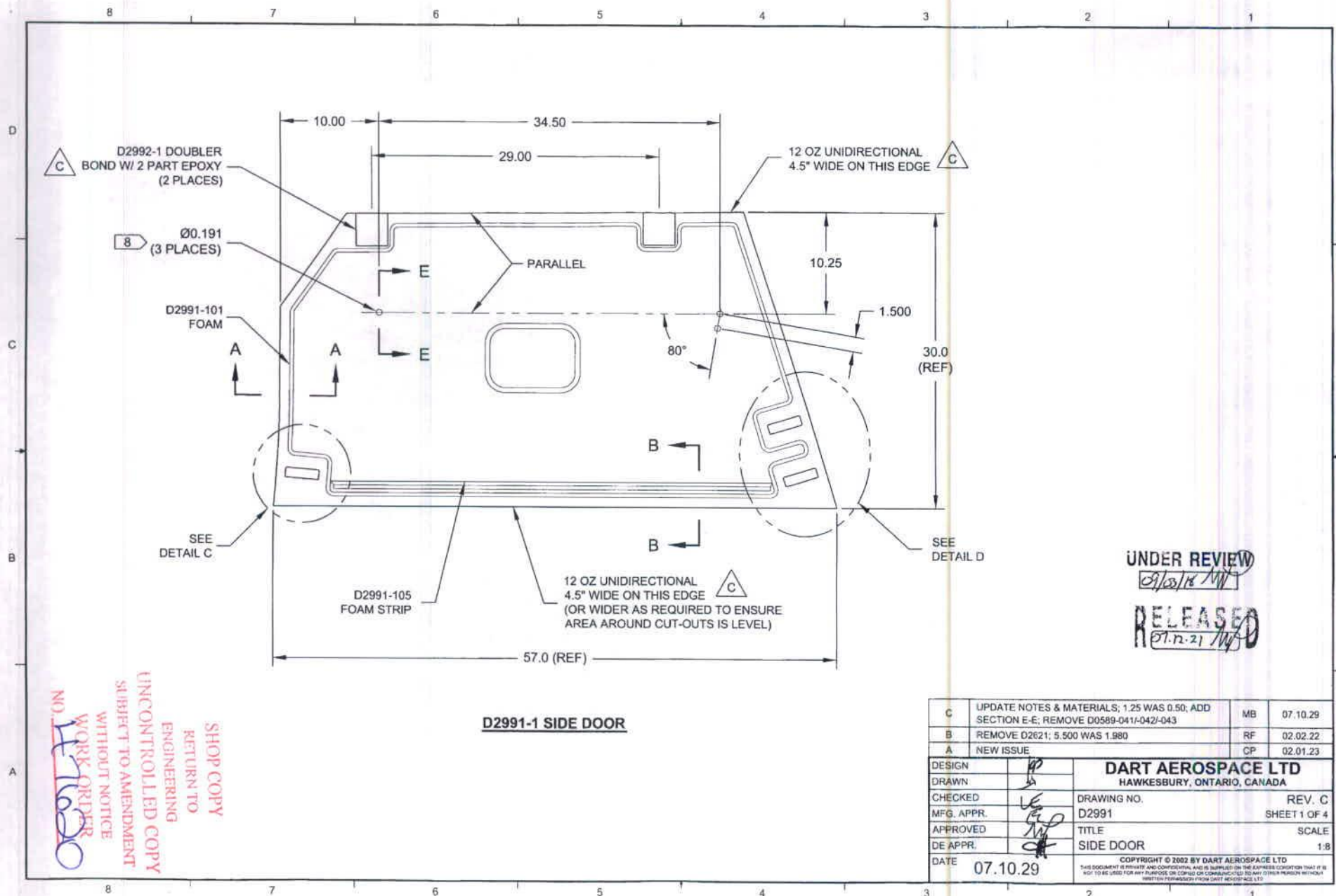
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

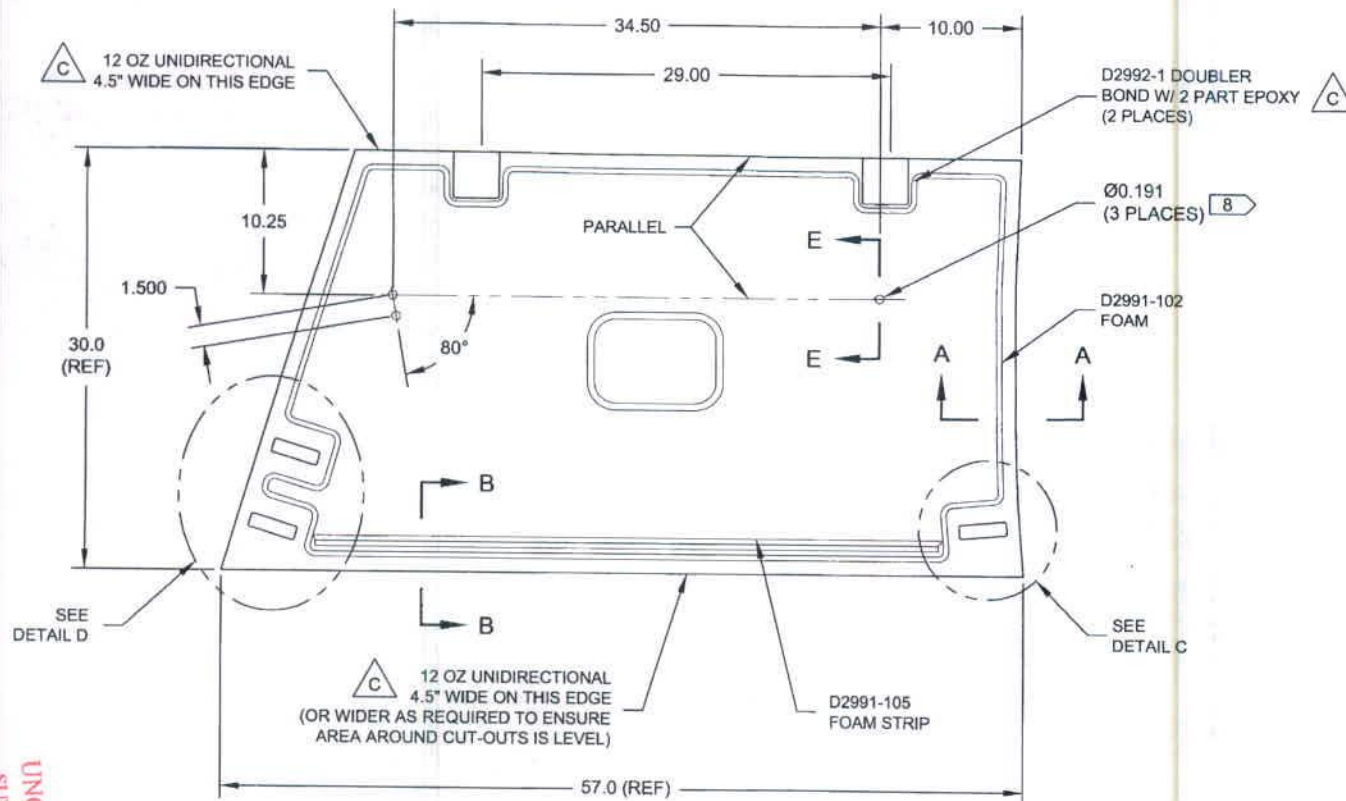
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date, & initial all entries



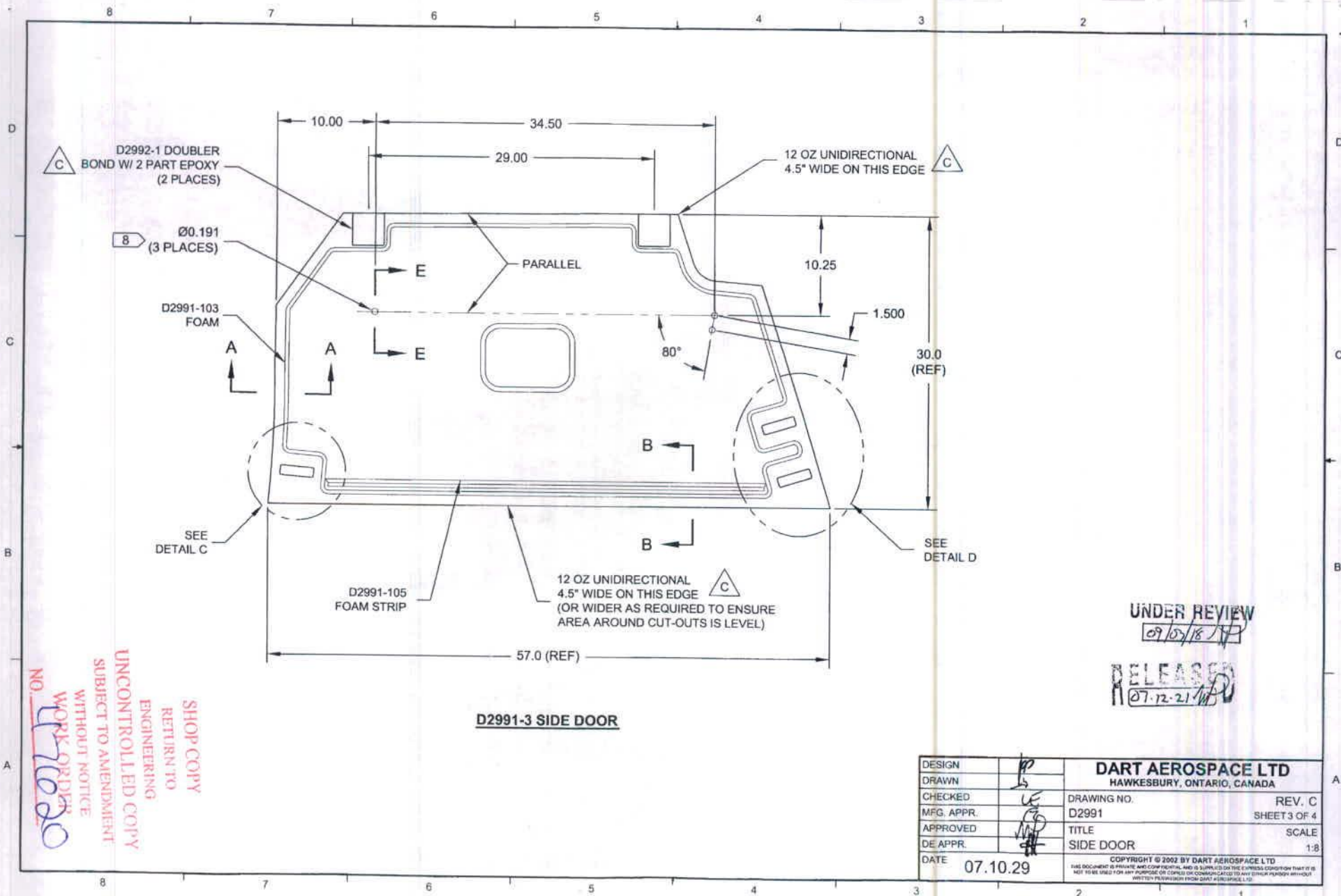


D2991-2 SIDE DOOR

UNDER REVIEW
 07/05/16
 RELEASED
 07.12.21

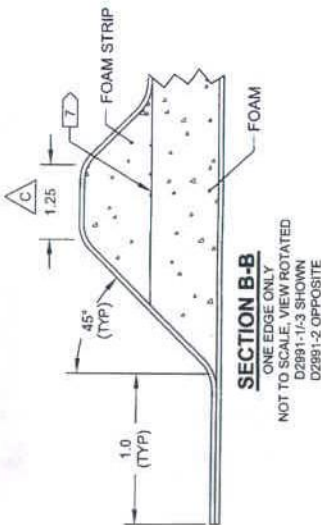
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2991	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	1
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 11000

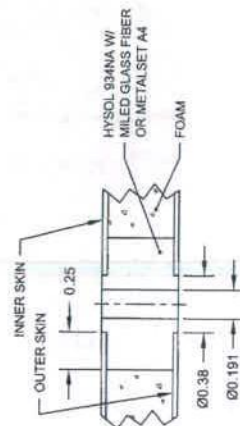
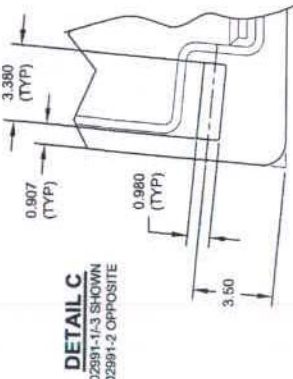
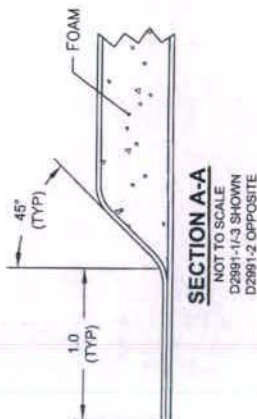
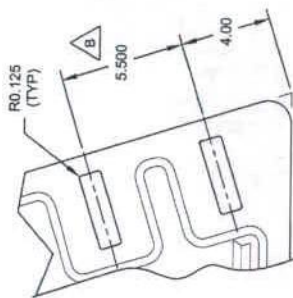


NOTES FOR D2991-1/2/3

- LAYUP PER QSI 006 AND AS FOLLOWS
- MATERIALS:
RESIN: EPOCAST 50-A9816 OR DERAKANE 470-35411/510A40
FOAM: 3/8" A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8628 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- ROUTER FOAM CORE USING:
DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- MAIN LAYUP:
WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM STRIP
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- BOND FOAM CORE USING POLYBOND B48F
- DRILL Ø0.38 HOLE REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: PER D2991-1/2/3 PPPs.
- WEIGHT: 9 lbs (TYP)



DETAIL D



SECTION E-E

TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 476000

DESIGN	REV. C
DRAWN	SHEET 4 OF 4
CHECKED	SCALE
MFG. APPR.	1:5
APPROVED	
DE APPR.	
DATE	07.10.29

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2991

TITLE

SIDE DOOR

DATE

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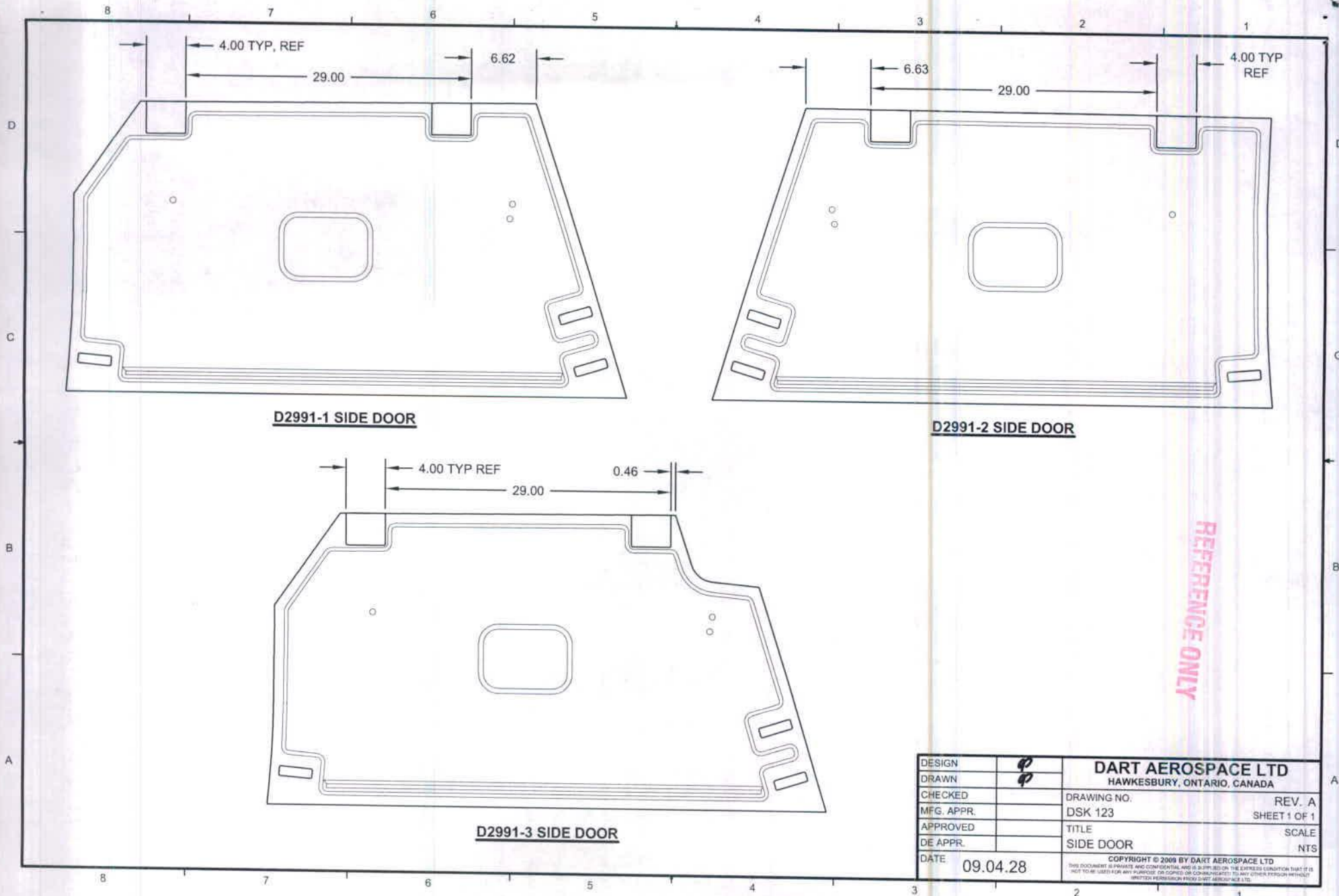
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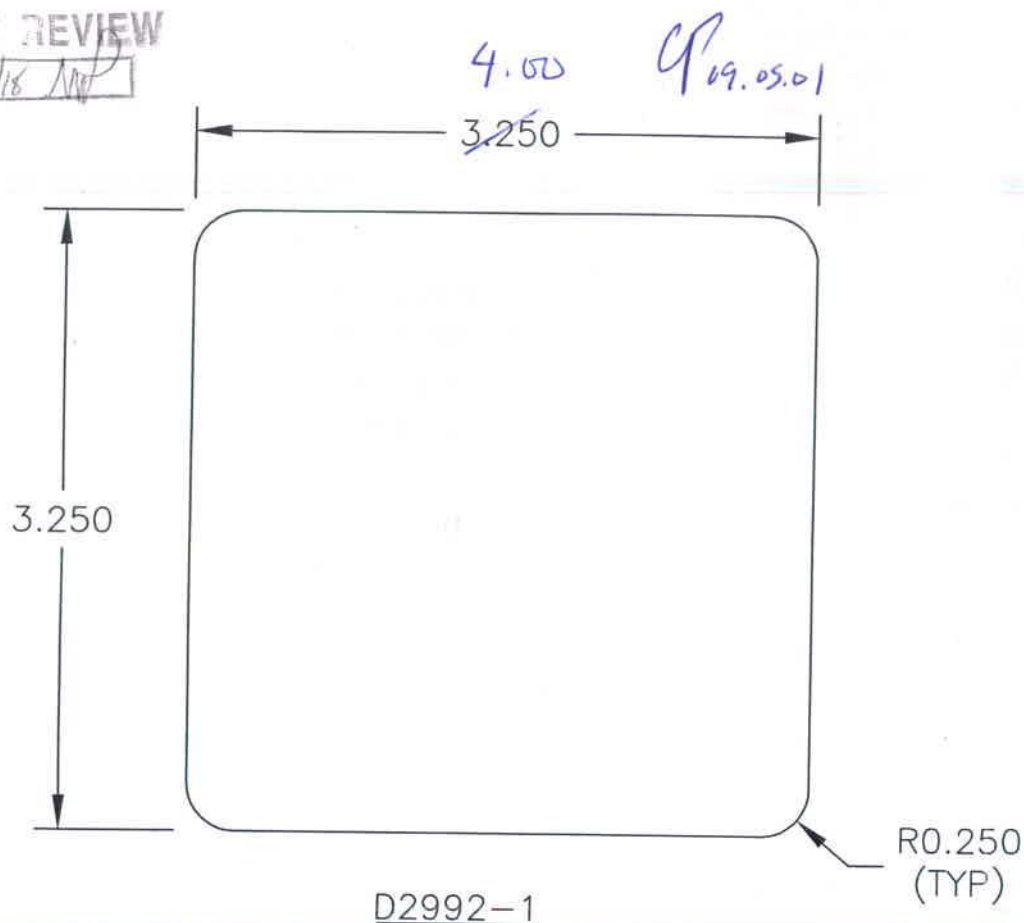


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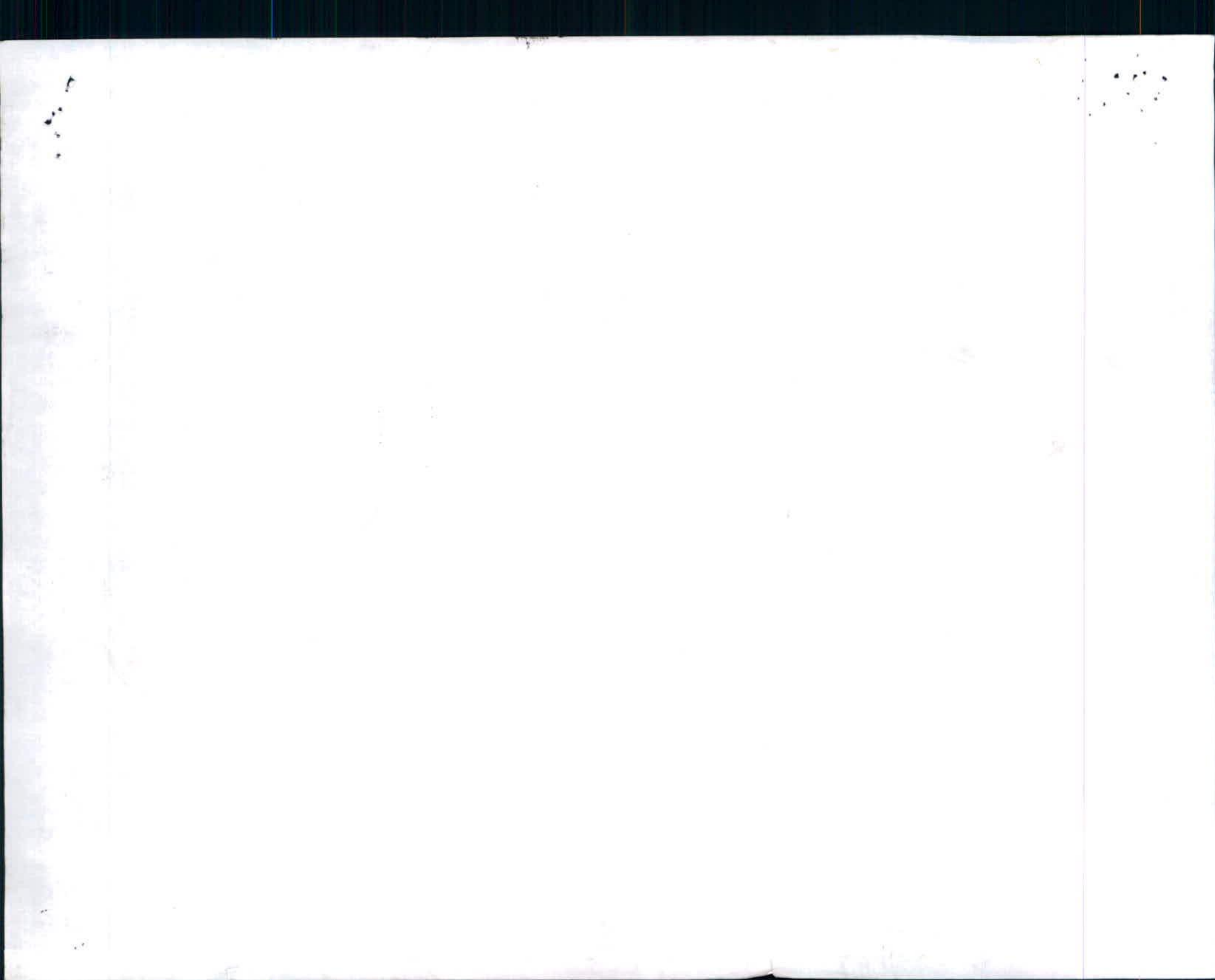
MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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52.4 PARTS LIST

47620

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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#47620

DART SERVICE INSTRUCTIONTO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E
ANDINSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1
REF CANADIAN STC: SH92-41
REF FAA STC: SH1012NE

D35X-589-041/-042/-043 Side Door Assembly kits at CHG 004 have an additional latch on the trailing edge to provide better fit and security. The side door kits at CHG 004 should be installed per IIN-D350-589 Rev. E, except a total of (4) D2237 striker plates are now installed. The parts list is updated as follows:

ADD:

Qty -041	Qty -042	Qty -043	Part Number	Description
X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
	X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
		X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
1	1	1	D2237	Striker Plate
1	1	1	D2585	Latch Clamp
1	1	1	D2586	Latch
1	1	1	D2621	Latch Plate
1	1	1	AN960JD10	Washer
2	2	2	MS20470AD4-5	Rivet
1	1	1	MS21042L3	Nut (or MS21042-3)
1	1	1	MS27039-1-15	Screw

The DSI-9463-011 kit is available for customers with earlier model D35X-589-041/-042/-043 doors to add an additional latch on the trailing edge of the door.

Qty -011	Part Number	Description
X	DSI-9463-011	DOOR LATCH KIT
1	D2237	Striker Plate
1	D2464-1700	Seal
1	D2585	Latch Clamp
1	D2586	Latch
1	D2621	Latch Plate
1	AN960JD10	Washer
2	MS20470AD4-5	Rivet
1	MS21042L3	Nut (or MS21042-3)
1	MS27039-1-15	Screw
2 SQ. FT	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE

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BRANCH
DAO # 01-O-01

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BY: *[Signature]*
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To install the DSI-9463-011 Door Latch Kit:

- 1) Remove the D35X-589-041/-042/-043 door from the aircraft. Remove the D2464-1700 Seal as required to access the composite structure.
- 2) Trim foam core of door 11.0" (280mm) above the aft door latch as shown in Figure 2 of this service instruction. Bevel foam at 45°.
- 3) Apply (2) layers of 9 oz cloth covering the trimmed area, as shown in Section A-A of this service instruction. Acceptable materials for the composite modification are specified in section 7.0 of QSI 037. Cure at room temperature for 24 hours.
- 4) Temporarily locate the D2621 Latch Plate as shown in Figure 3 of this service instruction. Use latch plate as a template and trace the inner rectangle. Cut a hole through the door skin using the traced rectangle to fit a D2586 Latch. Deburr edges of hole and seal edges with potting resin.
- 5) Touch-up the paint finish with one coat of MIL-P-23377 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 6) Install D2621 Latch Plate, D2585 Latch Clamp, D2586 Latch, and associated fasteners in accordance with Figure 52-4 of ICA-D350-589.
- 7) Reinstall the door on the aircraft using existing hardware.
- 8) Locate and install a D2237 Striker Plate opposite the new latch location per Figure 52-4 of ICA-D350-589.
- 9) Install the D2464-1700 Seal around the outside edge of the door as shown in Figure 52-4 of ICA-D350-589.
- 10) Check the doors and latches for proper operation by opening and closing the door. Adjust latches as required.

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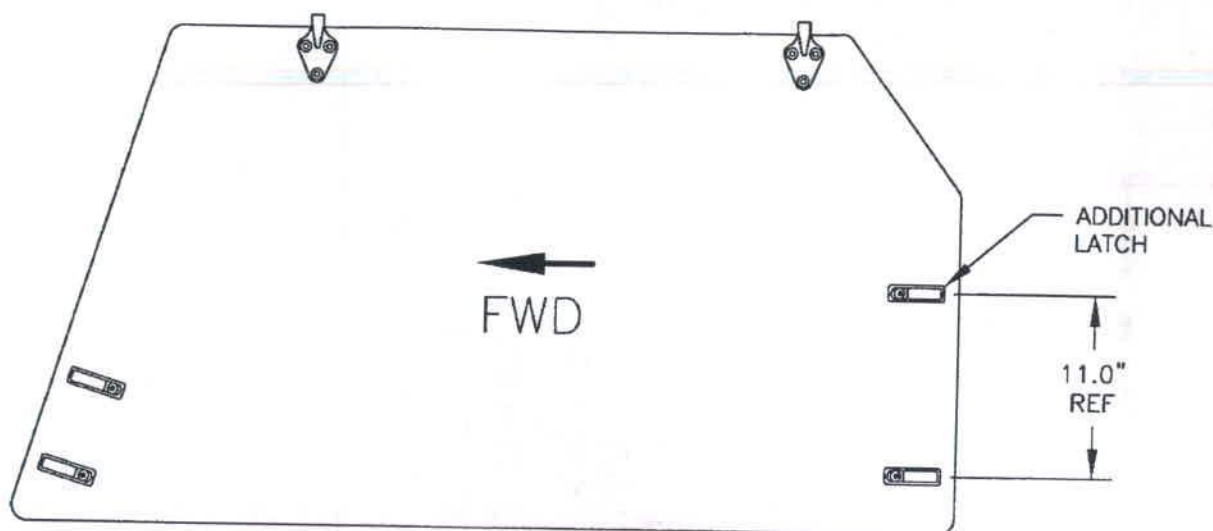
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#47620



**FIGURE 1: D350-589-041 DOOR ASSEMBLY (SHOWN)
D35X-589-042/-043 (SIMILAR)**

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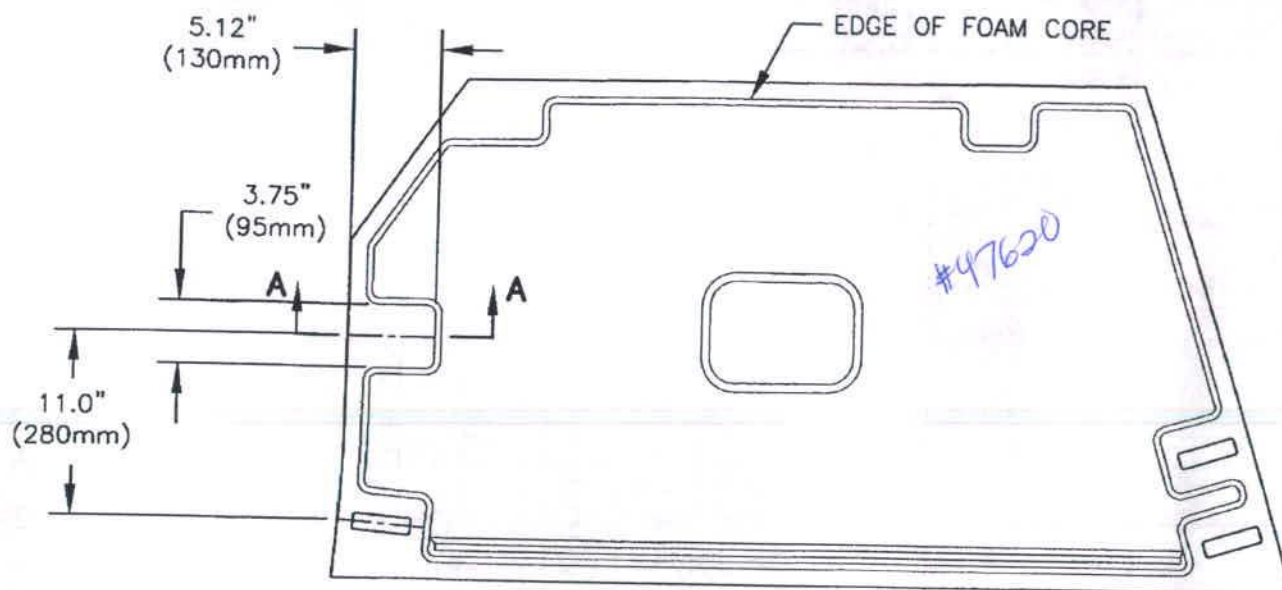
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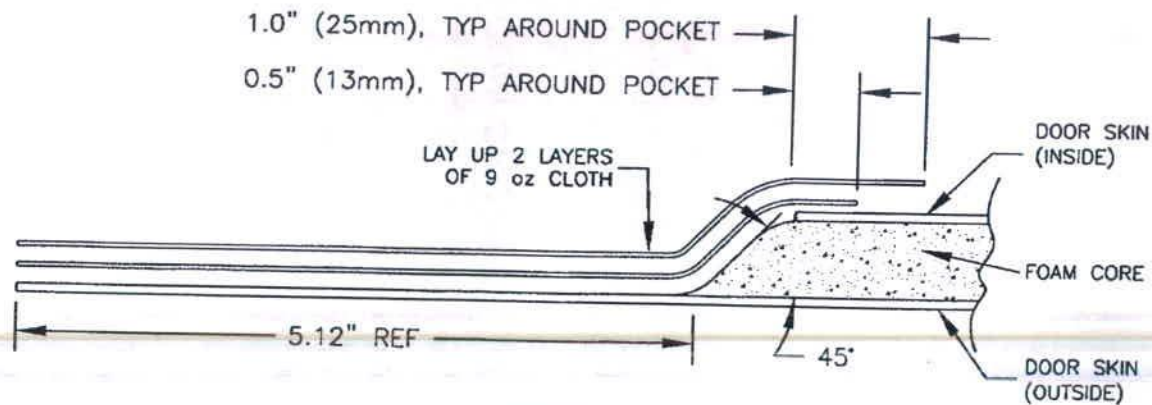
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**FIGURE 2: TRIMMING FOAM CORE
(VIEW LOOKING AT INSIDE OF DOOR)
(-041 SHOWN. -042/-043 SIMILAR)**



SECTION A-A

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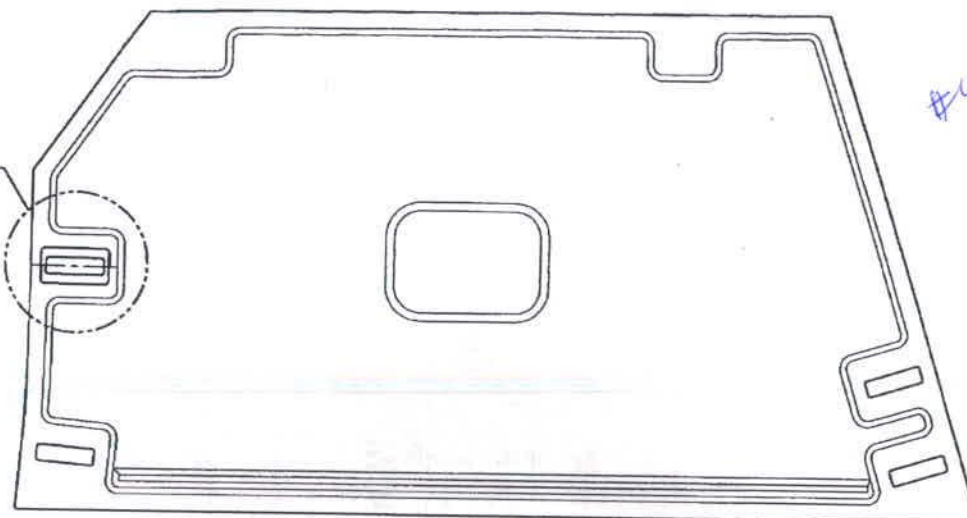
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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SEE
DETAIL B



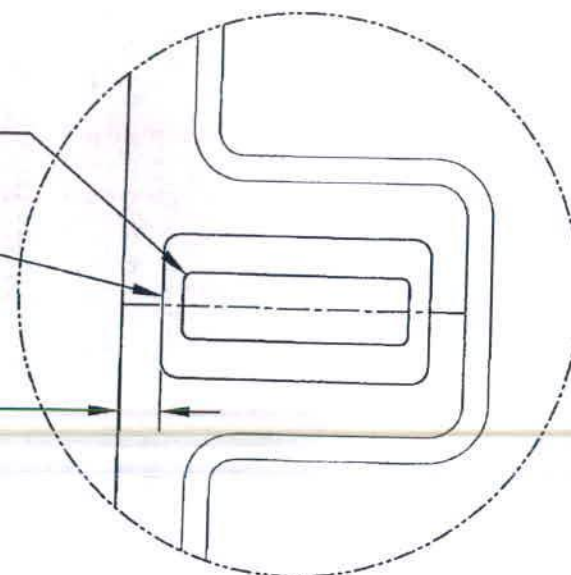
#47620

FIGURE 3: CUTTING LATCH HOLE

CUT HOLE THROUGH
SKIN USING D2621 AS
TEMPLATE

D2621 LATCH PLATE

0.60"
(15.2mm)



DETAIL B

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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52-00-00

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER
 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER
 REF. TCCA STC: SH92-41
 REF. FAA STC: SH1012NE
 REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for the relocation of the door switch when the D35X-589-041/-042/-043 Side Door Assemblies are installed per D350-589 Rev. E and earlier and to clarify that the OEM center latch is not required with the D35X-589-041/-042/-043 kits.

The DSI 9446-011 Switch Relocation Kit may be installed by relocating the door switch using the following procedure:

- 1) Remove the existing door switch (p/n 2-5445), switch support (p/n 350A67-6323-32) and spring (p/n 350A67-6323-31) from the forward lower edge of the cargo compartment.
- 2) Position the D3894-1 switch plate near the bottom of the flange adjacent to the cargo compartment floor so that the switch will contact the door directly. See Figure 1.
- 3) Locate and drill 2x $\varnothing 0.129$ (#30 drill) holes from D3894-1 switch plate to the cargo compartment flange. Deburr holes and attach D3894-1 switch plate to the flange of the cargo compartment using 2x MS20470AD4 rivets.
- 4) Position the door switch in the hole provided in the D3894-1 switch plate.
- 5) Reconnect wiring to switch (if removed) and verify that switch operates correctly. It may be necessary to hand-form/trim the D3894-1 switch plate slightly to ensure that the switch contacts the door properly.

If the cargo compartment has a second switch installed in the center latch, it is not necessary to relocate this switch. The wiring should be removed and stowed so that this switch no longer turns on the cockpit indication.

There is no weight and balance change for the installation of the DSI 9446-011 switch relocation kit.

The D3894-1 switch plate will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9446-011	Switch Relocation Kit
1	D3894-1	Switch Plate

CANADA
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 BRANCH
 DAO # 01-O-01

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MFG. APPR.	N/A	DSI 9446	SHEET 1 OF 2
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NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER
REF. TCCA STC: SH92-41
REF. FAA STC: SH1012NE
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for recessing the forward upper latch of the D35X-589-041/-042/-043 Side Door Assemblies for compatability with OEM sliding doors. Without this modification the OEM sliding door may contact the upper latch as the door is opened.

The DSI 9447-011 Latch Adjustment Kit may be installed as follows:

- 1) Remove sliding door guide (p/n 350A21-1375-21/-20) and shim (p/n 350A21-1376-20) from existing door and relocate to D35X-589-041/-042/-043 door assembly. See Figure 2 for drilling and repair details. Install using existing hardware.
- 2) Mark around the edge of the upper forward D2586 door latch on the outer door surface.
- 3) Remove the upper forward D2586 door latch and trim the hole to the line marked in the previous step. D2586 door latch should now be able to pass through the hole.
- 4) Position the D3895-1 doubler on the inside of the door with the cutout centered over the newly enlarged hole.
- 5) Transfer drill 16x $\phi 0.129$ (#30 drill) from the doubler to the D35X-589-041/-042/-043 side door. Countersink the 16 holes $\phi 0.179 \times 100^\circ$ from the outside of the door. Deburr holes and attach D3895-1 doubler to the D35X-589-041/-042/-043 door with qty. (16) MS20426AD4 rivets. See Figure 1.
- 6) Re-install the D2586 door latch per D350-589 and/or ICA-D350-589.
- 7) Verify that the door closes and latches correctly. Adjust latches per ICA-D350-589.
- 8) Apply blade tape (Ref. 3M p/n 8560-2) to the D35X-589-041/-042/-043 side door to prevent contact wear from the OEM sliding door.

There is no weight and balance change for the installation of the DSI 9447-011 latch adjustment kit.

The D3895-1 Joubler will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9447-011	Latch Adjustment Kit
1	D3895-1	Doubler

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.02.04
CERT. NO.: SH92-41
ISSUE NO.: 7

A	NEW ISSUE	BY: <i>[Signature]</i>	09.02.04
REV.	DESCRIPTION	BY	DATE
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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9447	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LATCH ADJUSTMENT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries